

BLUE

Dart Aerospace Ltd.

Date: Thursday, 6/21/2007 2:27:05 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE  
 Job Number : 33032  
 Estimate Number : 10831  
 P.O. Number : N/A Part Number : D29321 *W*  
 This Issue : 6/21/2007 S.O. No. : N/A Drawing Number : D2932 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : C  
 Previous Run : 32377 Material : N/A  
 Due Date : 6/28/2007 Qty: 8 Um: Each  
 Written By : *W*  
 Checked & Approved By : *W*  
 Comment : Est: B 00.06.26 New DWG rev, (mpp 2069) EC  
 Est Rev: C As per Rev C 07-03-19 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101003 7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

7075-T7351 2X6.25X7.875

Issue material from stock:

7075-T7351 Cut Size 2.0 x 6.25 X 7.880 Grain Along Long 7.88 Length

Batch No.: *B31387*

*W*

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

5-Deburr & TUMBLE

*W/SD 05.07.07*

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

*W/SD 05.07.07*

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

*W/SD 05.07.07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 2:27:05 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE

Job Number: 33032

Part Number: D29321

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.1 07/07/08

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

5.1

07-07-12

8

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

- PRIME  
- PAINT DELFLEET BLUE  
- CLEAR DELFLEET

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: \_\_\_\_\_

stock unpainted

6-7/12/12

8

UP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/07/12

Job Completion



6 07-07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	33032
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b>	D2932-1
<b>Inspection Dwg:</b> D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.126	0.129	.129	.128		
B	0.100	0.140		0.130	0.127	.130	.129		
C	0.100	0.140		0.118	0.119	.122	.125		
D	0.210	0.230		0.224	0.224	.224	.224		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.510	.510	.510	.510		
I	1.572	1.582		1.576	1.576	1.577	1.577		
J	2.495	2.505		2.499	2.499	2.499	2.500		
K	0.257	0.262		0.258	0.258	.258	.258		
L	0.312	0.317		0.315	.314	.314	.314		
M	0.235	0.240		0.239	.239	.239	.239		
N	0.100	0.140		0.119	0.121	.121	.121		
O	0.540	0.560		0.545	0.546	.547	.547		
P	0.490	0.510		0.501	.500	.499	.499		
Q	3.715	3.725		3.717	3.717	3.718	3.719		
R	2.470	2.510		2.492	2.493	2.493	2.493		
S	0.240	0.270		0.255	0.254	.255	.255		
T	0.100	0.180		0.140	0.140	.140	.140		
U	1.625	1.635		1.629	1.628	1.629	1.629		
V	1.362	1.372		1.368	1.366	1.367	1.367		
W	0.316	0.321		0.319	0.319	.318	.318		
X	1.125	1.145		1.135	1.135	1.135	1.135		
Y	1.565	1.585		1.573	1.574	1.573	1.574		
Z	0.178	0.198		0.188	0.188	0.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	MR / SA
Date:	07/07/04 / 07.07.05

Audited by:	J.L
Date:	07/07/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>33032</b>
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b>	<b>D2932-1</b>
<b>Inspection Dwg:</b> D2932 Rev. C		<b>Page 1 of 1</b>

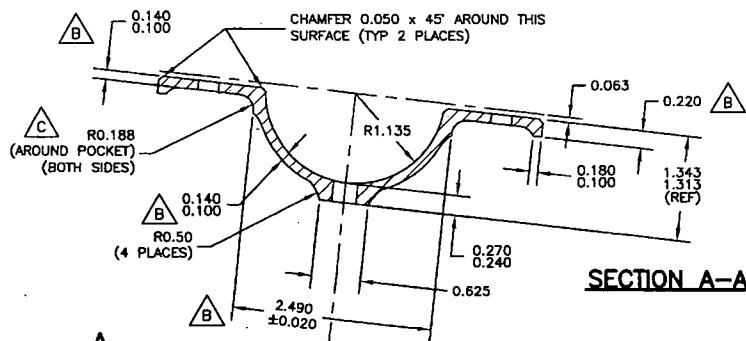
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.127	.128	.127	.127		
B	0.100	0.140		.128	.127	.127	.127		
C	0.100	0.140		.128	.126	.125	.127		
D	0.210	0.230		.225	.225	.224	.224		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.576	1.577	1.577	1.577		
J	2.495	2.505		2.501	2.495	2.500	2.498		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.122	.122	.122	.122		
O	0.540	0.560		.547	.547	.547	.545		
P	0.490	0.510		.497	.498	.497	.496		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.484	2.484	2.484	2.484		
S	0.240	0.270		.256	.255	.255	.256		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.625	1.625	1.625	1.629		
V	1.362	1.372		1.367	1.367	1.366	1.366		
W	0.316	0.321		.318	.318	.318	.318		
X	1.125	1.145		1.137	1.138	1.137	1.138		
Y	1.565	1.585		1.571	1.571	1.571	1.572		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

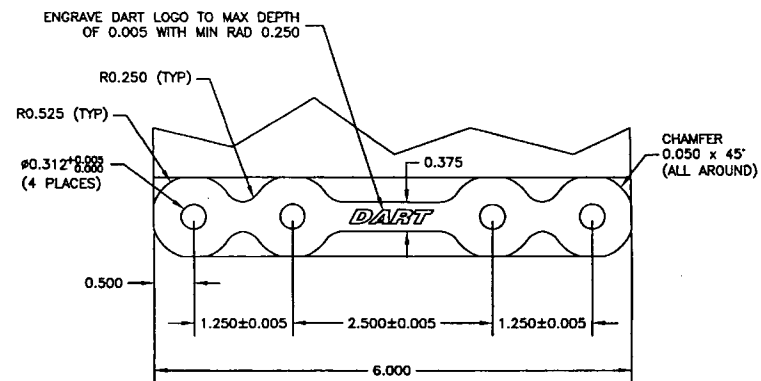
Measured by:	<i>SL</i>
Date:	01.07.05

Audited by:	<i>JL</i>
Date:	07/07/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690.	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>



SECTION A-A



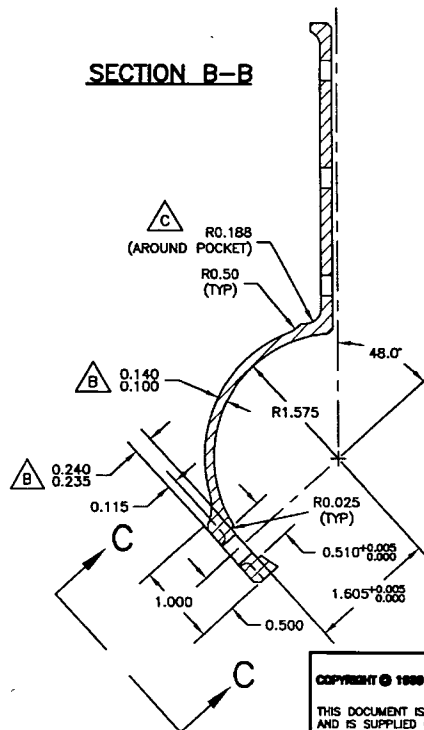
VIEW C-C

**D2932-1 LH SADDLE (SHOWN)**  
**D2932-2 RH SADDLE (OPPOSITE)**

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
  - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE OUTSIDE
		REV. C
		SHEET 1 OF 1
		SCALE
		2:3

SECTION B-B



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